

Date: Tuesday, 3/11/2008 7:57:28 AM
User: Kim Johnston

Process Sheet

split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 37745 -1	Part Number	: D22301
Estimate Number	: 10255	Drawing Number	: D2230 REV F
P.O. Number	:	Project Number	: N/A
This Issue	: 3/11/2008 S.O. No. :	Drawing Revision	: F
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : MACHINED PARTS	Due Date	: 3/31/2008
Previous Run	: 36747	Qty:	200 100 Um: Each
Written By	:		
Checked & Approved By	: <i>JA 08 03 11</i>		
Comment	: Est D 00 11.01 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s)

Lug Extrusion D2423 Extrusion

Batch: *B33310*

CY08/03/12

(7.1715)

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut D2423 extrusion to 0.82"

Batch:

N/A issue P/O - 5896
meter as per deng.
REV.F

CY08/03/12

(200)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio D2230-1

(Check for crack while loading into the machine.)

2-Tumble and deburr rough edges after tumbling

sec'd + inspect for damage

P 8/3/20

(120)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QCB	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08.03.24

(120)

counted (120) inspected per QX P 019

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:28 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 37745

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



** Tumble per Seq. 3.0*



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

EB 08/03/24 (120)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/26 (120) caentes

8.0

POWDER COATING

POWDER COATING



M107005



(120X)

Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

m-1 08/03/26

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/03/26 (120)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PO 8/3/26 (120)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

120 08/03/27

Job Completion



mf 08-03-27 (120)
W

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

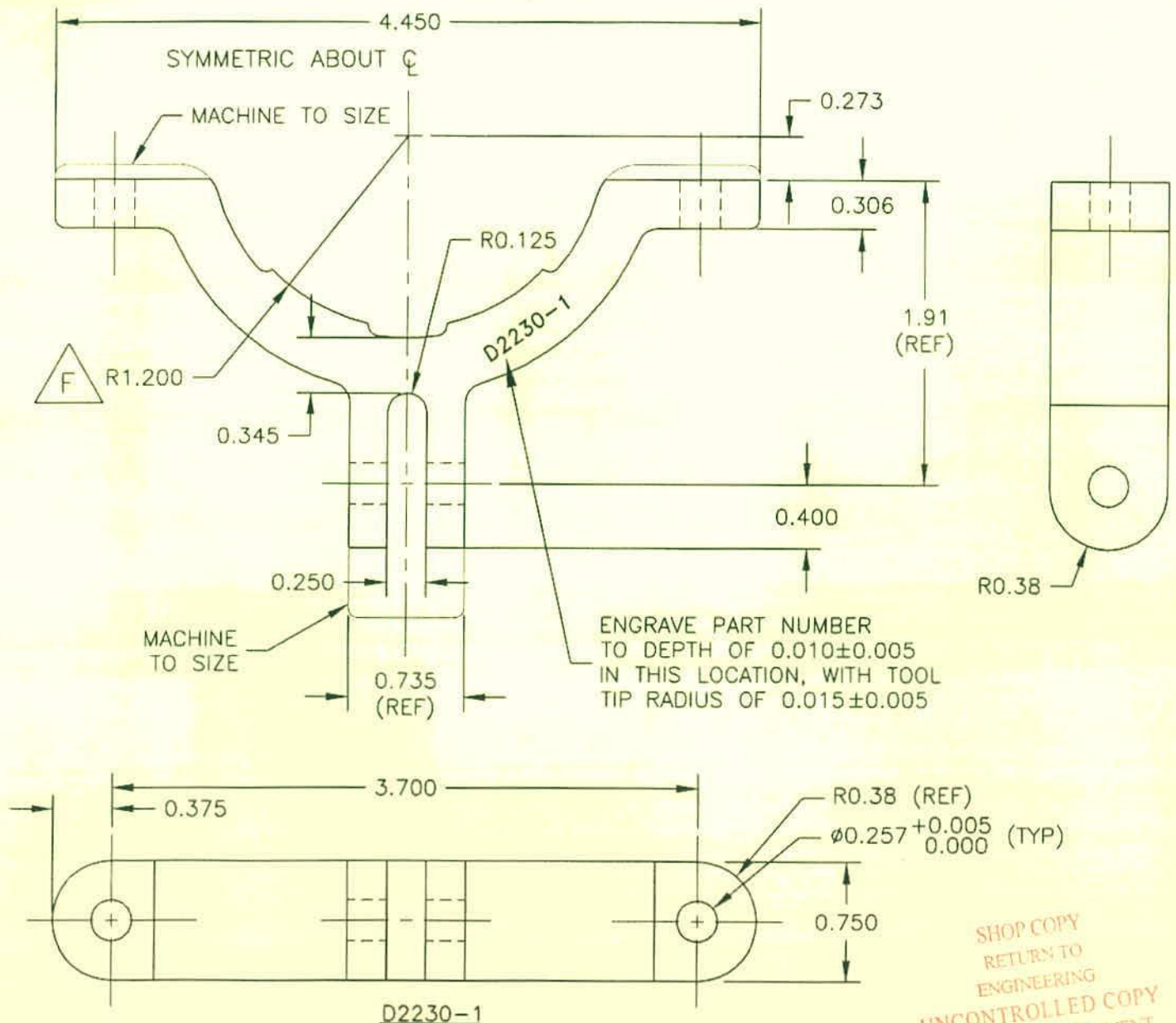
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D2230
DATE	99.12.13	TITLE	MOUNTING LUG	REV. F SHEET 1 OF 2 SCALE 1:1
C	94.03.30	RE-DESIGN		
D	95.01.04	RE-DESIGN		
E	95.01.04	RE-DESIGN		
F	99.12.13	REDESIGN; R1.200 WAS R1.100		

RELEASED
99.12.21 DS

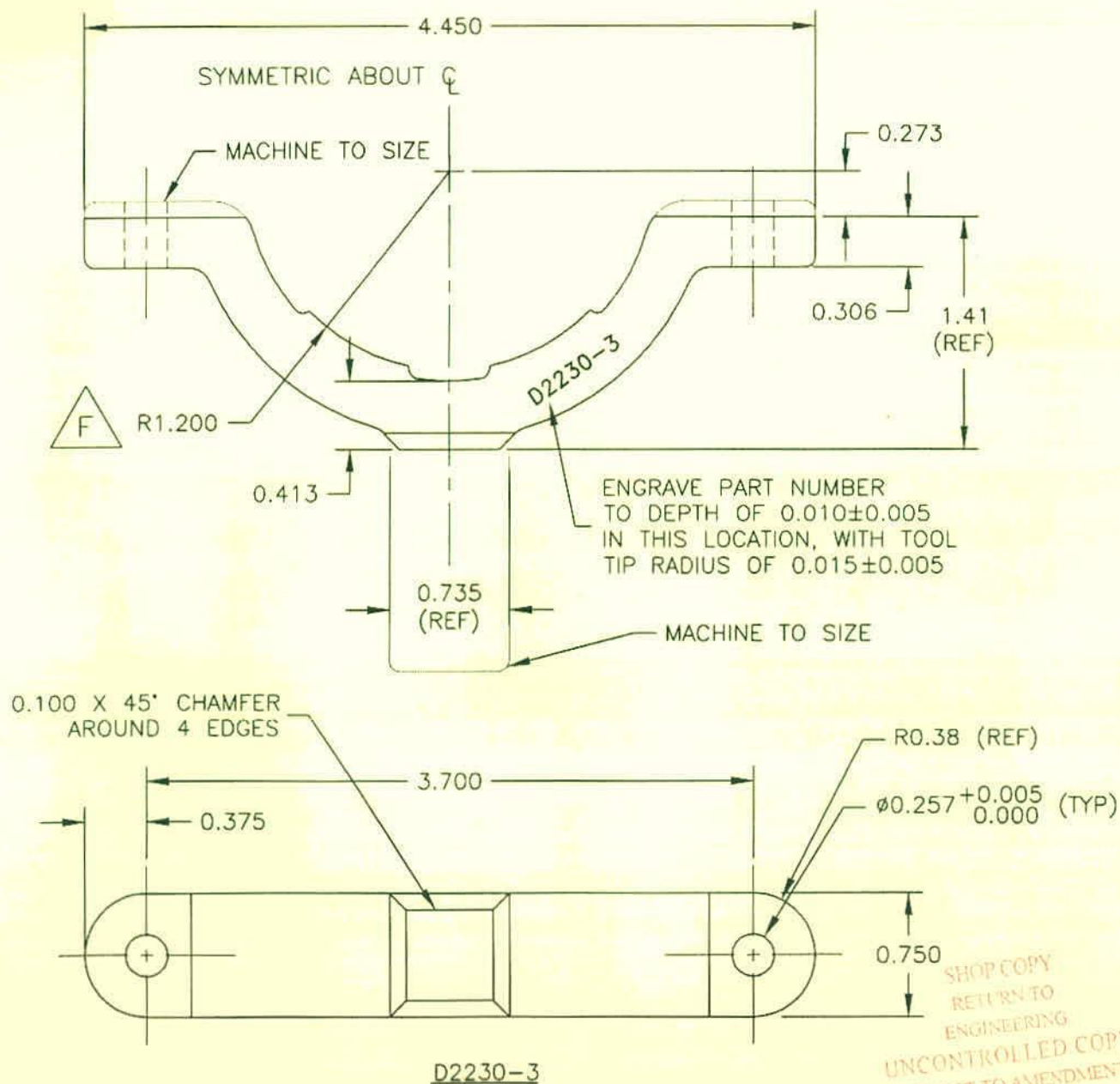


MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37745

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
79.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 37745

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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

120

D2230-1


Mounting Lug

5896

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.



Denise Robinson

Vankleek Hill, March 20, 2008

